

Work Order ID 124612

September-17-14 10:52:04 AM

124612

Page 1

Item ID: D3589-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 9/17/14 Start Qty: ~~4.00~~ **3** ***4*** Cust Item ID:
 Required Date: 9/19/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3589	C								

100 0.00
100
 Small Fab Memo 0.00 3 FF 14-09-17
 Small Fab 1- cut D3589-1 as per dwg D3589
 2- chamfer both ends as per dwg D3589
 3- deburr

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00 (3) 14-09-19 DAS
 Quality Control 9-89

120 Identify as per dwg & Stock Location DVA002 0.00
120
 Packaging Memo 0.00 3x 14-9-22 DAS
 Packaging 26
 9-89

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MLJ 14-09-23
MLJ 14-09-22

Picklist Print

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Work Order ID: 124612

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Parent Item: D3589-1

D3589-1

Parent Item Name: Arm

Start Date: 9/17/14

Required Date: 9/19/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-29 new issue DD verified by:EC
02-20 rev.b asper dwg DD verified by:EC
IPP Rev:B 09-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.375W.065

Purchased

No

100

f

9.8380

1.65

7

M304TR0 375W 065

**

DAS
30
9.88

14/09/17

304 RD Tube .375 x .065W

Location

Loc Qty

Loc Code

MAT016

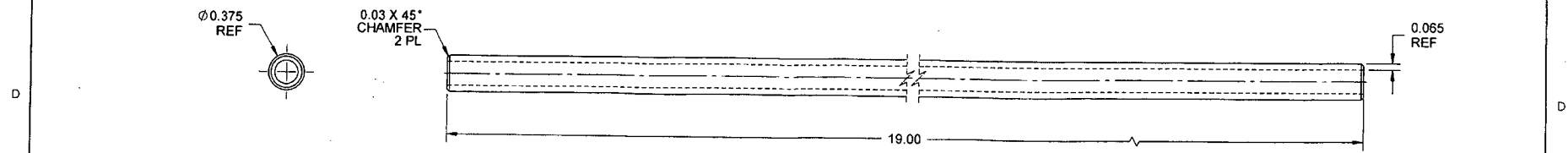
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✓124768

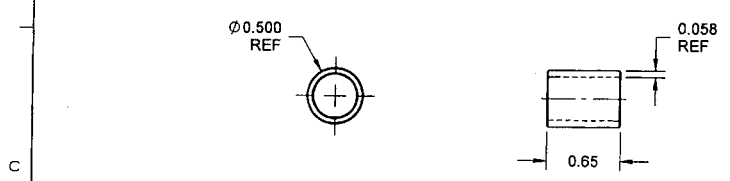
9.838

9.838

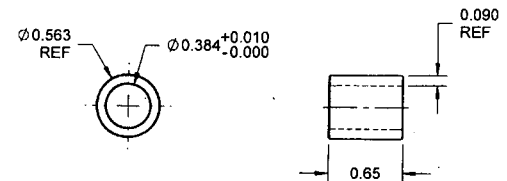
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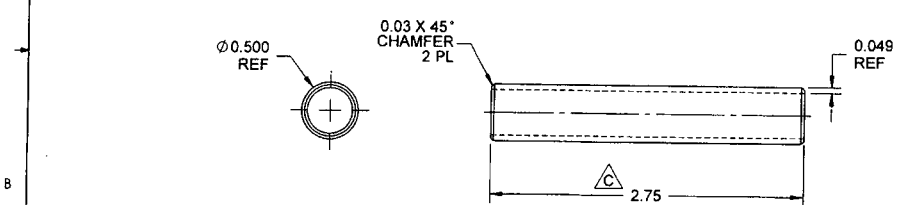
D3589-1 ARM



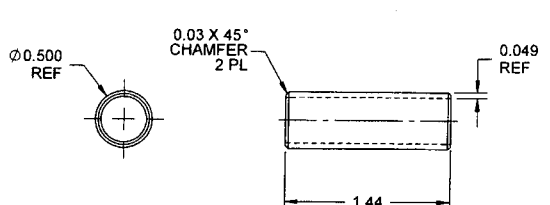
D3589-3 ARM GUIDE



D3589-23 ARM GUIDE



D3589-5 LATCH GUIDE



D3589-21 LATCH GUIDE

- D3589-1/-3/-5/-21/-23 NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
 D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
 D3589-5/-21: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
 D3589-23: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276 (REF. DART SPEC M304R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs
 - D3589-21 = 0.03 lbs
 - D3589-23 = 0.02 lbs

W/O 24612

RELEASED
2012-07-16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3589	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	12.07.04	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COPIED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1